

60001 HEX 1"

Work Order ID 149371

July 22, 2016 3:08:22 PM

149371

HMOD -

Page 1

Item ID: D2806-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Bushing

Start Date: 9/22/2016 Start Qty: 100.00 *100*

Required Date: 9/30/2016 Req'd Qty: 100.00 *100*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: SW Date: 7/25/14 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2806	Rev A								

100 DOOSAN LATHE 0.00

100

Doosan Memo 1.17

Doosan Lathe 1- Turn as per Folio FA105 Rev: AA & Dwg D2806 Rev: A 2-Deburr per dwg D2806

101 0 DAS 45 9-89 2016-08-12

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.17

Quality Control

101 0 DAS 45 9-89 2016-08-12

120 QC8- Inspect parts - second check 0.00

120

QC Memo 0.33

Quality Control

101 0 SL 168-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
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OTHER : _____																									

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.17				(101)			2-16-15 JL 9-89 BEB
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.17				(101)			DAS 38 9-89 AUG 15 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST012A</u> Memo	0.00 0.17				county scale (101)	DAS 6 9-89		AUG 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

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160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	1.67							
Quality Control									

DAS
21
9-89
AUG 16 2016

DAS
21
9-89
AUG 16 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Picklist Print

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Page 1

Work Order ID: 149371

149371

Parent Item: D2806-1

D2806-1

Parent Item Name: Bushing

Start Date: 9/22/2016

Required Date: 9/30/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: B05.03.11Part now turned KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6H1.000		Purchased		No		100	f	2.5473	0.0916	9.64211			

M6061T6H1 000

**

6061-T6 HexBar 1.00

Location

MAT017

m127797

m135377

Loc Qty

2.5473468

2.5473468

Loc Code

DAI

45

9-89

2016-08-12

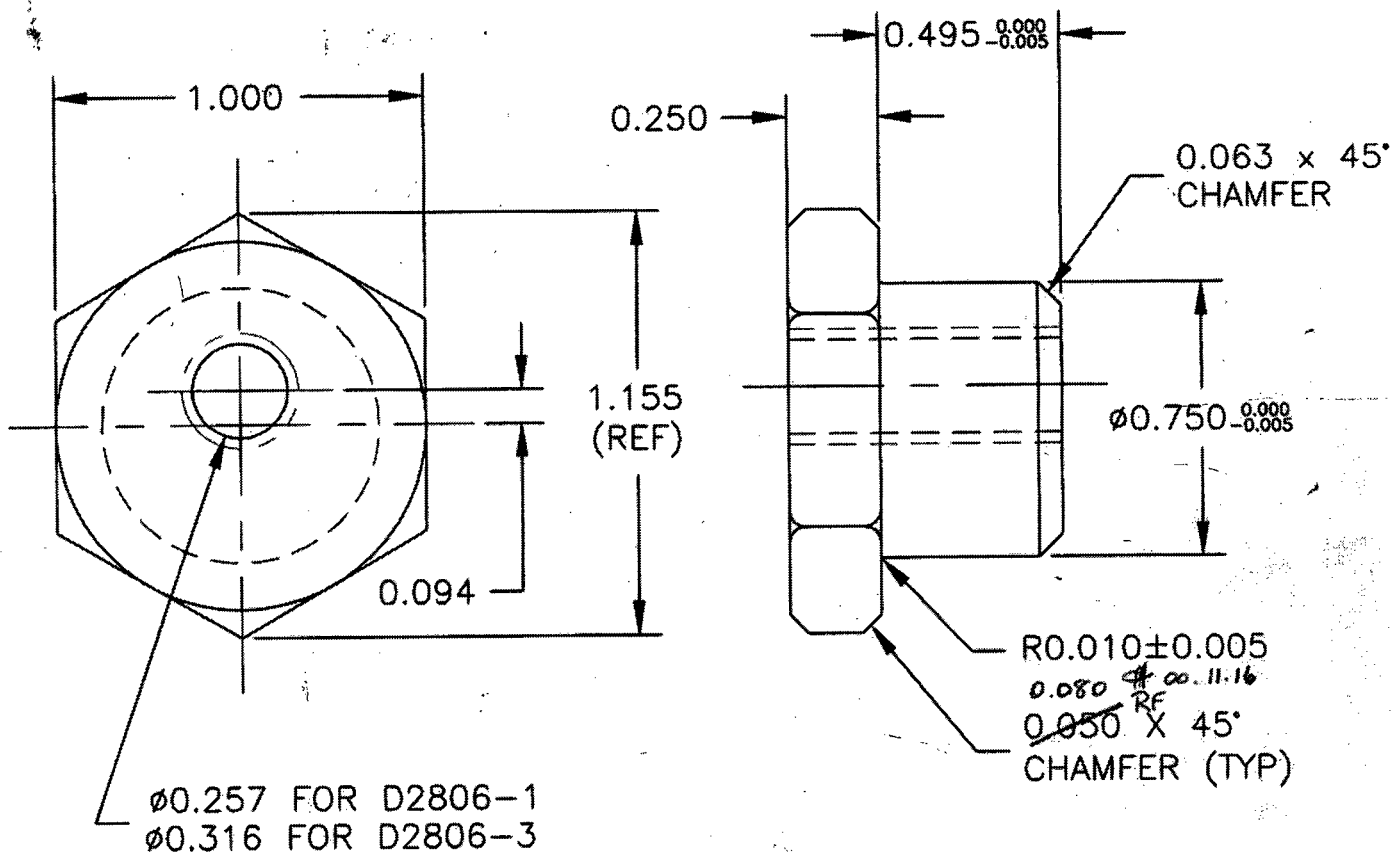
2,547,346.8
S/L ~~22~~ 11
8,147,346.8

3/23



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*



14.9 371

D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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